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(54) **SEMICONDUCTOR DEVICES AND METHODS OF MANUFACTURE THEREOF**

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H01L 23/532 (2006.01)
H01L 21/768 (2006.01)
H01L 21/66 (2006.01)

(52) **U.S. Cl.**

CPC **H01L 23/528** (2013.01); **H01L 21/31116**

(2013.01); **H01L 21/76802** (2013.01); **H01L 21/76807** (2013.01); **H01L 21/76829** (2013.01); **H01L 21/76832** (2013.01); **H01L 21/76834** (2013.01); **H01L 23/5329** (2013.01); **H01L 23/53238** (2013.01); **H01L 23/53295** (2013.01); **H01L 22/26** (2013.01)

(58) **Field of Classification Search**

USPC 257/773; 438/634
See application file for complete search history.

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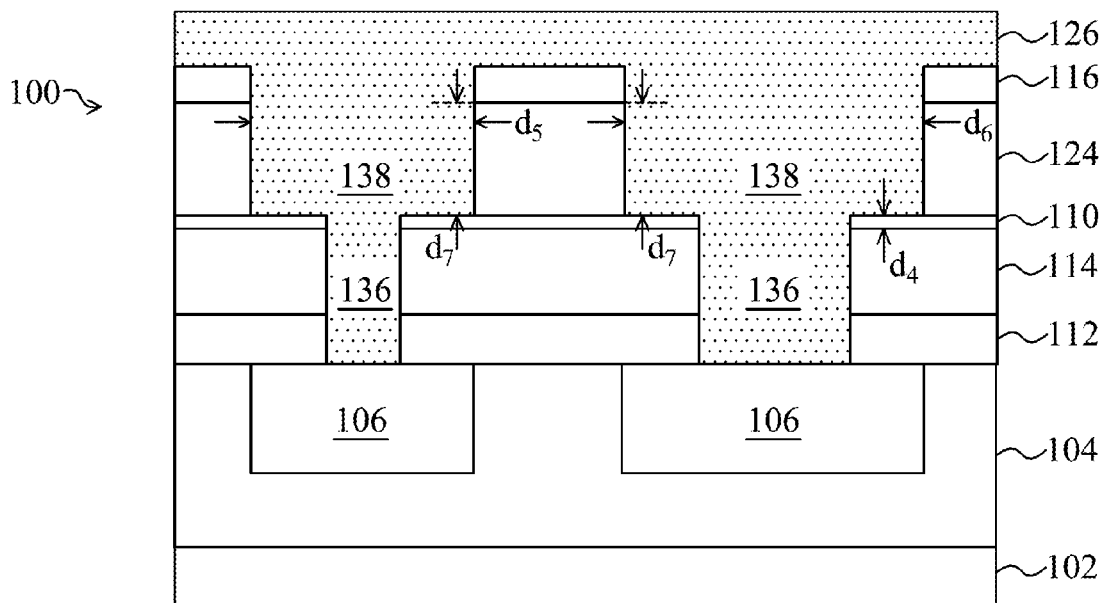
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(57) **ABSTRACT**

Semiconductor devices and methods of manufacture thereof are disclosed. In some embodiments, a method of manufacturing a semiconductor device includes forming an etch stop layer over a workpiece. The etch stop layer has an etch selectivity to a material layer of the workpiece of greater than about 4 to about 30. The method includes forming an insulating material layer over the etch stop layer, and patterning the insulating material layer using the etch stop layer as an etch stop.

20 Claims, 6 Drawing Sheets



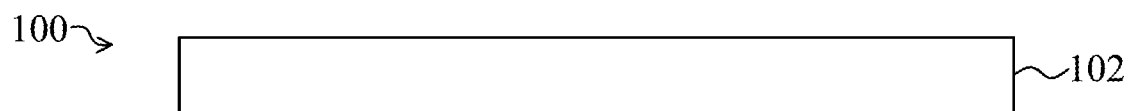


Fig. 1

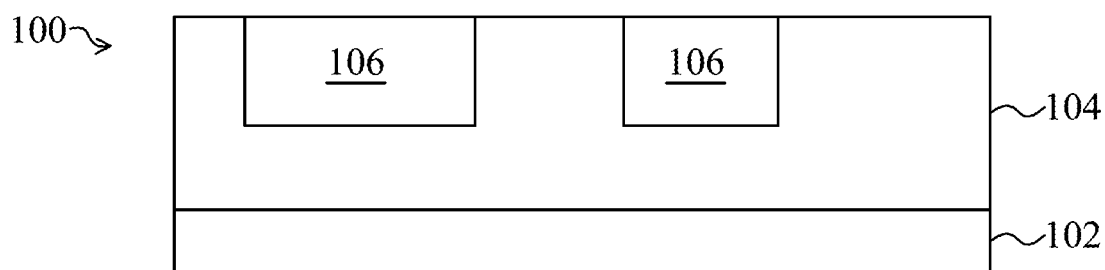


Fig. 2

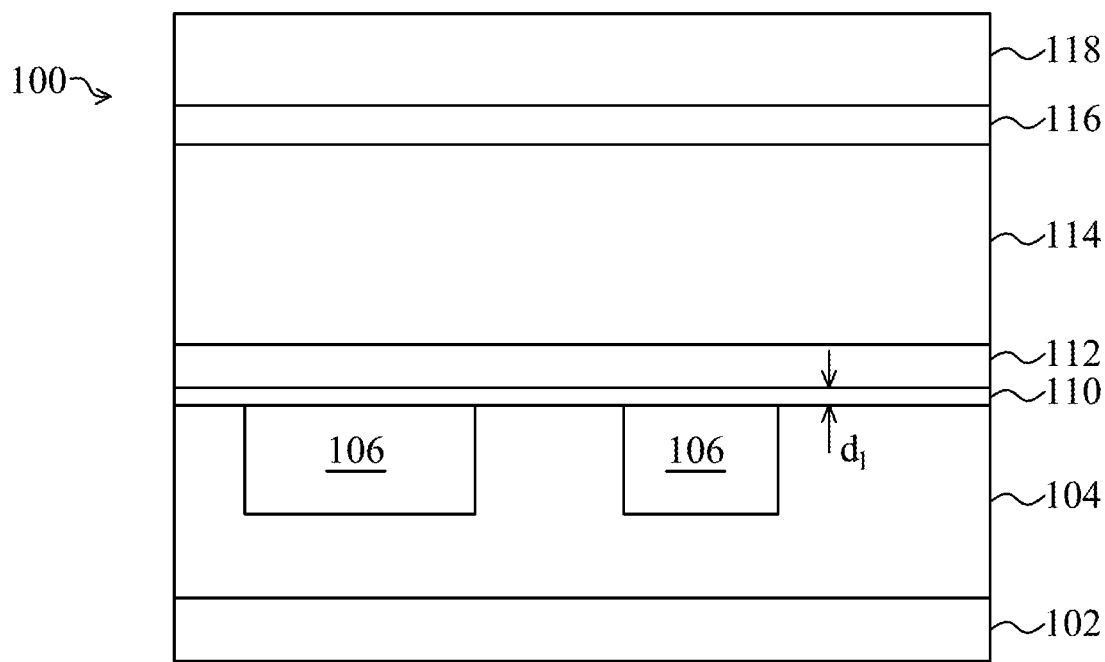


Fig. 3

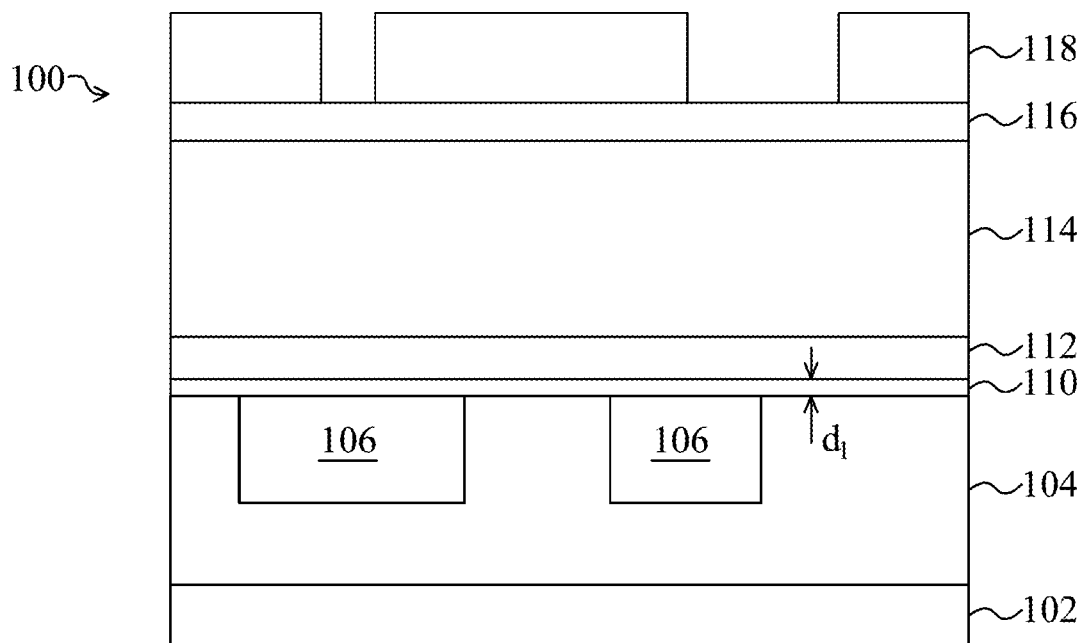


Fig. 4

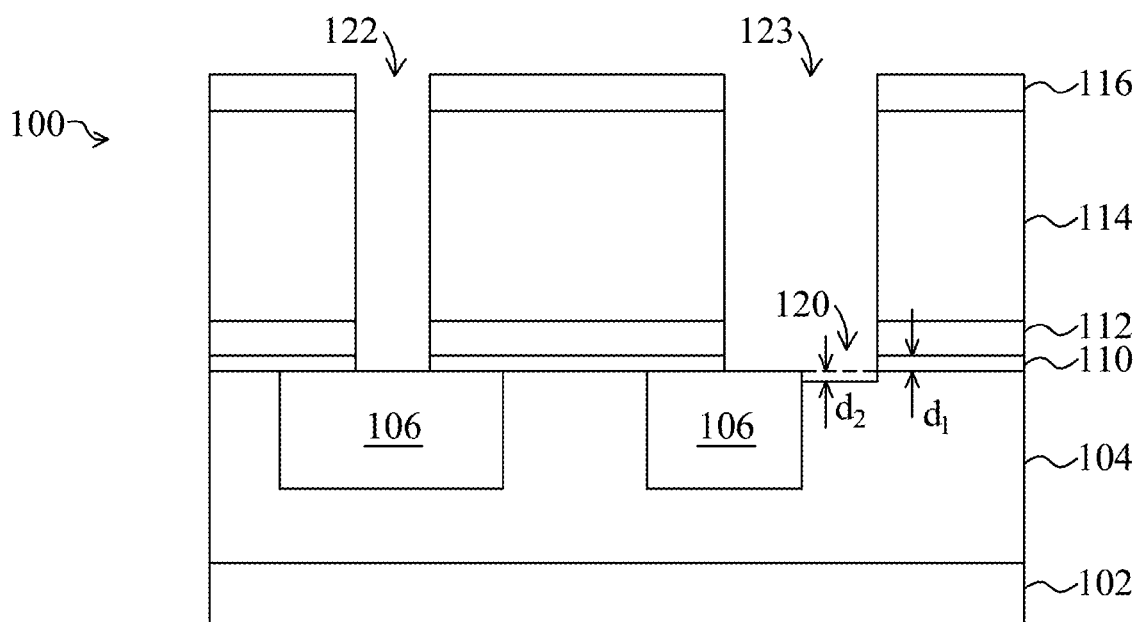


Fig. 5

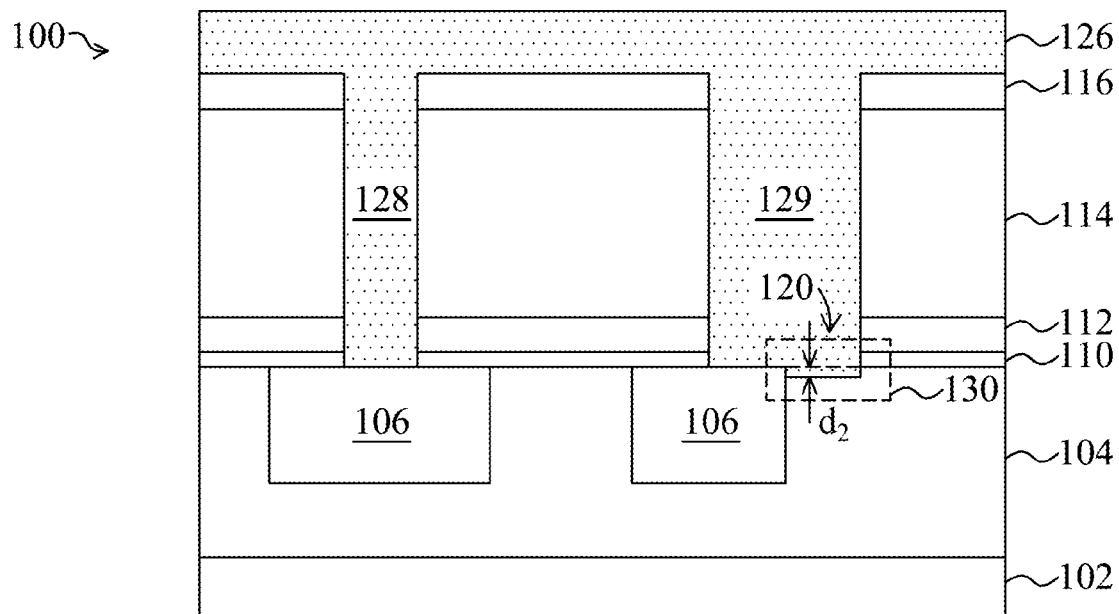


Fig. 6

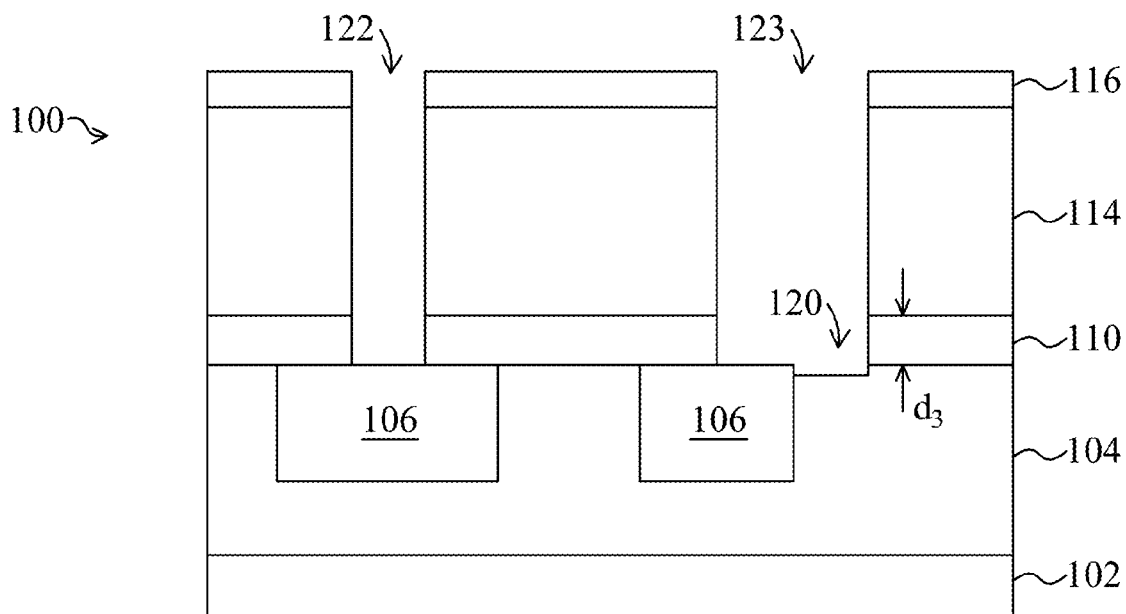


Fig. 7

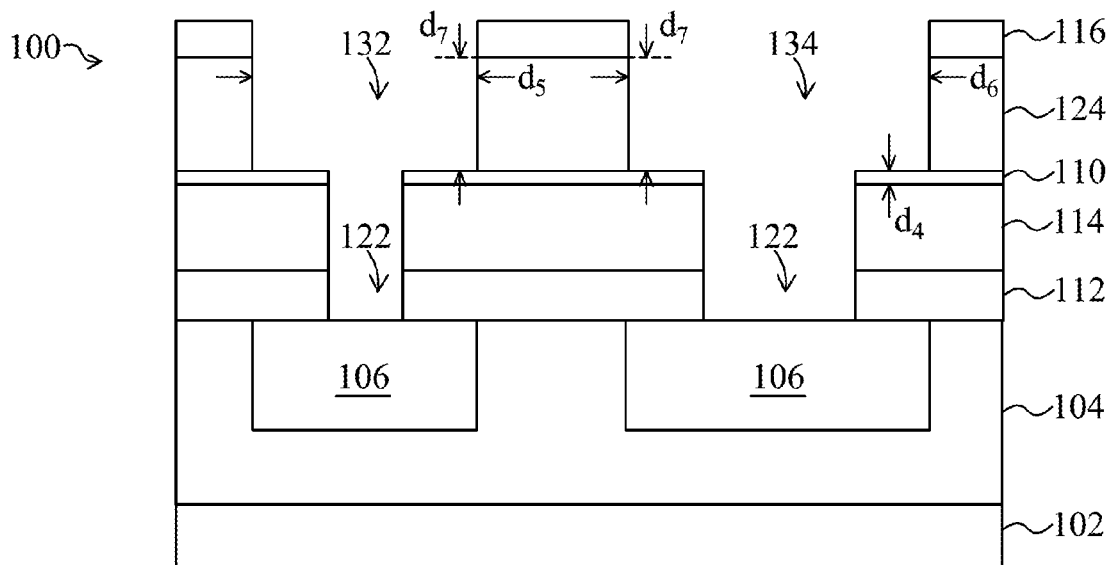


Fig. 8

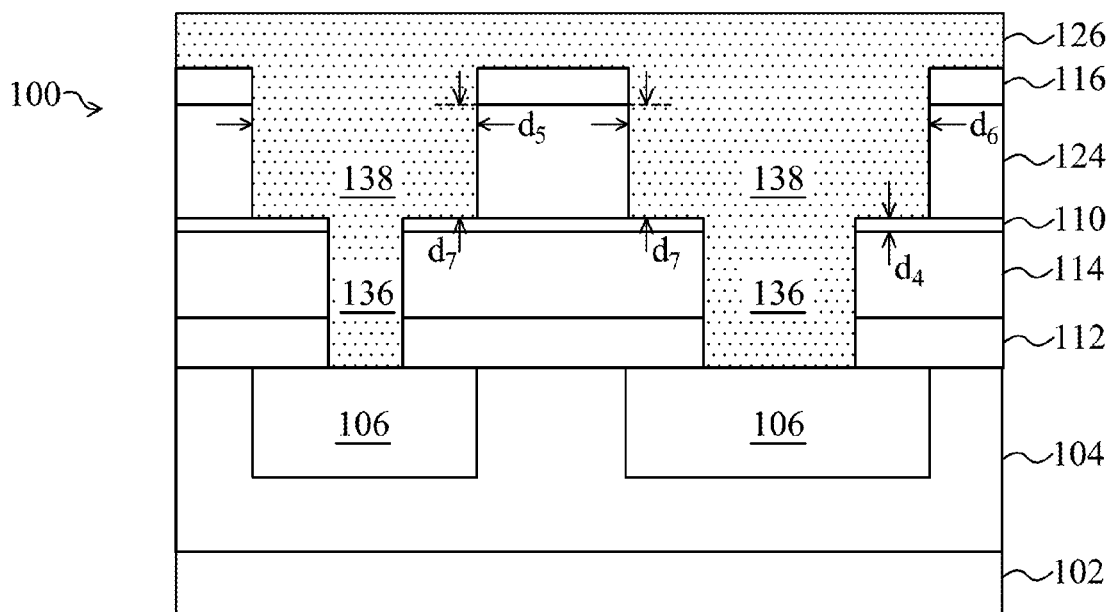


Fig. 9

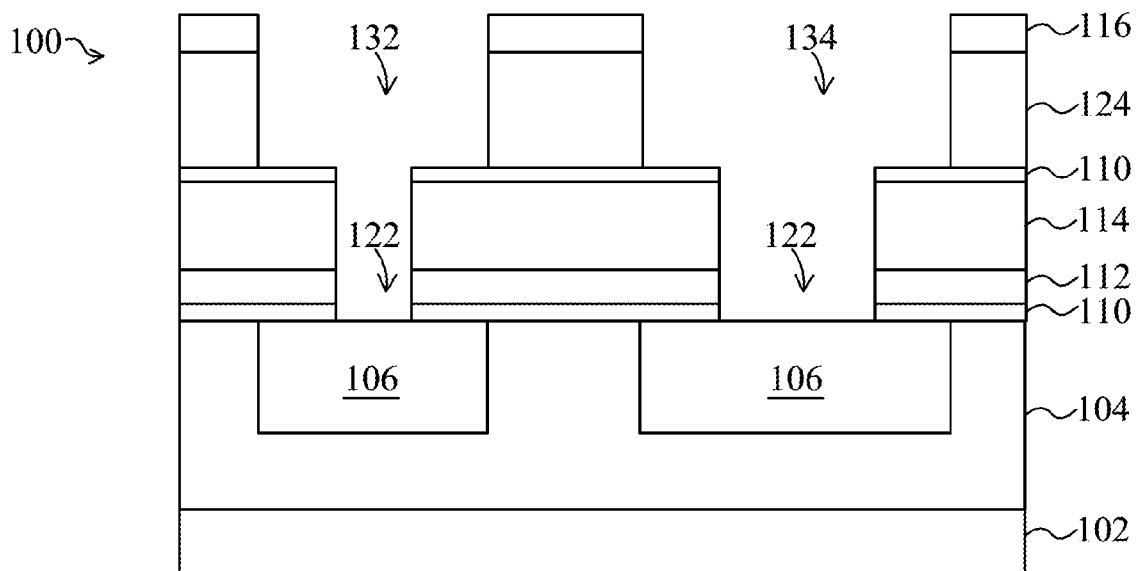


Fig. 10

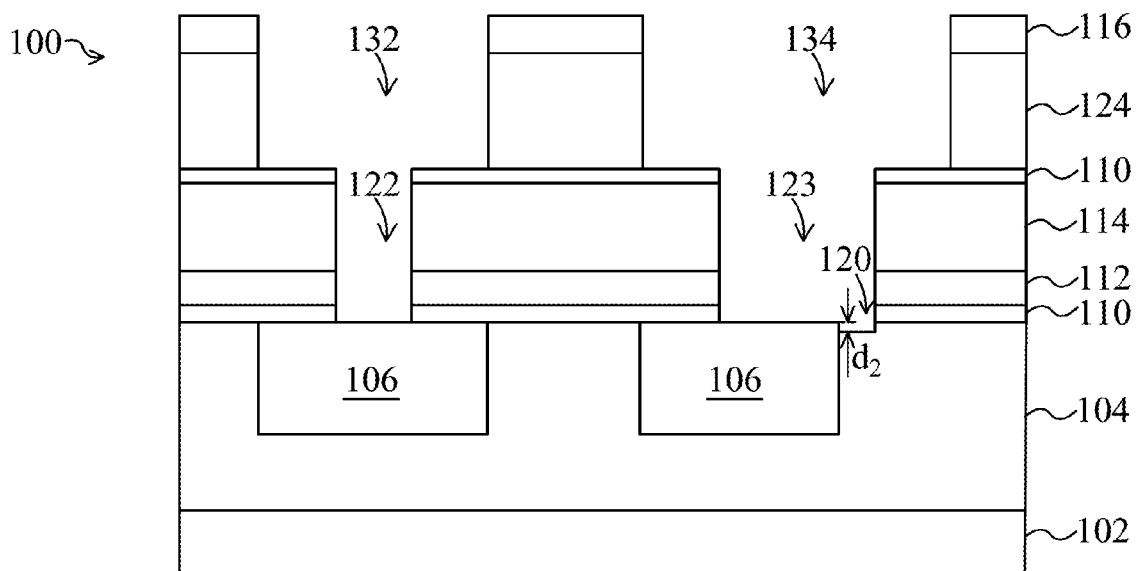


Fig. 11

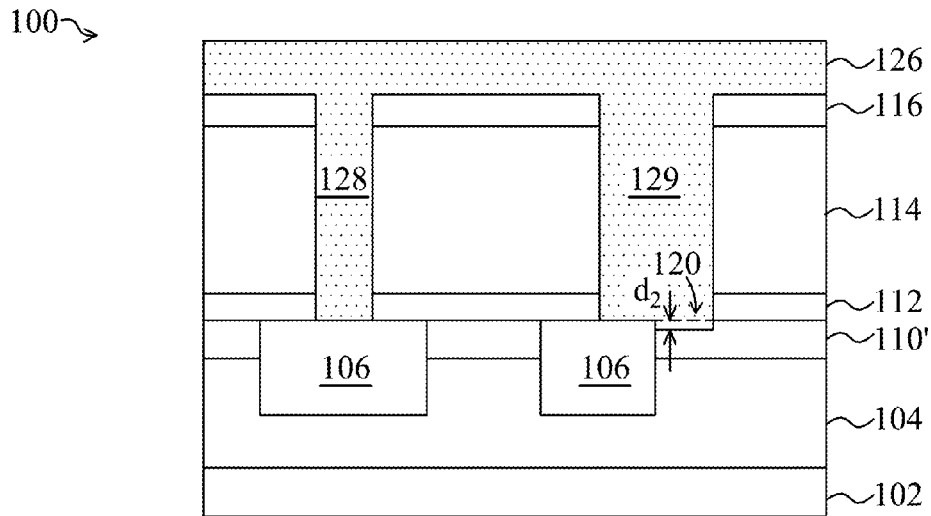


Fig. 12

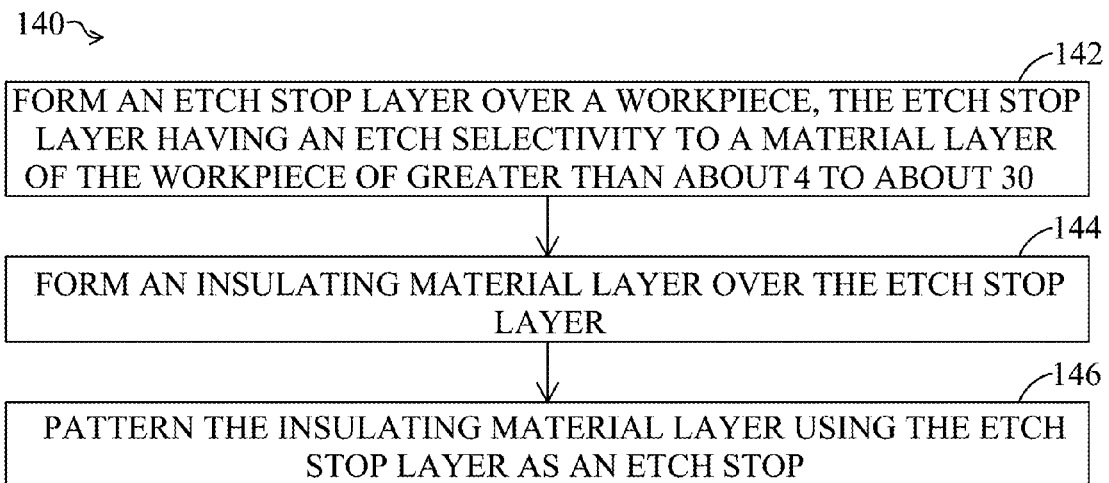


Fig. 13

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SEMICONDUCTOR DEVICES AND METHODS OF MANUFACTURE THEREOF

This application claims the benefit of U.S. Provisional Application No. 61/785,366, entitled "Semiconductor Devices and Methods of Manufacture Thereof," filed on Mar. 14, 2013, which is incorporated herein by reference.

BACKGROUND

Semiconductor devices are used in a variety of electronic applications, such as personal computers, cell phones, digital cameras, and other electronic equipment, as examples. Semiconductor devices are typically manufactured by providing a workpiece, forming various material layers over the workpiece, and patterning the various material layers using lithography to form integrated circuits.

The semiconductor industry continues to improve the integration density of various electronic components of integrated circuits, i.e., transistors, diodes, resistors, capacitors, etc., by continual reductions in minimum feature size, which allow more components to be integrated into a given area.

Conductive materials such as metals or semiconductors are used in semiconductor devices for making electrical connections for the integrated circuits. For many years, aluminum was used as a metal for conductive materials for electrical connections, and silicon dioxide was used as an insulator. However, as devices are decreased in size, the materials for conductors and insulators have changed, to improve device performance. Copper is now often used as a conductive material for interconnects in some applications. Low dielectric constant (k) materials and extra-low k (ELK) materials that have dielectric constants less than that of silicon dioxide have begun to be implemented in some designs as insulating materials between interconnects.

BRIEF DESCRIPTION OF THE DRAWINGS

For a more complete understanding of the present disclosure, and the advantages thereof, reference is now made to the following descriptions taken in conjunction with the accompanying drawings, in which:

FIGS. 1 through 6 illustrate cross-sectional views of a semiconductor device at various stages of manufacturing in accordance with some embodiments of the present disclosure;

FIG. 7 is a cross-sectional view of a semiconductor device in accordance with some embodiments;

FIGS. 8 and 9 are cross-sectional views of a semiconductor device at various stages of manufacturing in accordance with some embodiments;

FIGS. 10 and 11 are cross-sectional views of semiconductor devices at various stages of manufacturing in accordance with some embodiments;

FIG. 12 is a cross-sectional view of a semiconductor device in accordance with some embodiments; and

FIG. 13 is a flow chart of a method of manufacturing a semiconductor device in accordance with some embodiments.

Corresponding numerals and symbols in the different figures generally refer to corresponding parts unless otherwise indicated. The figures are drawn to clearly illustrate the relevant aspects of the embodiments and are not necessarily drawn to scale.

DETAILED DESCRIPTION OF ILLUSTRATIVE EMBODIMENTS

The making and using of some of the embodiments of the present disclosure are discussed in detail below. It should be

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appreciated, however, that the present disclosure provides many applicable inventive concepts that can be embodied in a wide variety of specific contexts. The specific embodiments discussed are merely illustrative of specific ways to make and use the disclosure, and do not limit the scope of the disclosure.

Some embodiments of the present disclosure are related to manufacturing methods and structures for semiconductor devices. Novel semiconductor devices and methods of manufacture thereof will be described herein that include etch stop layers having a high etch selectivity. The etch stop layers are implementable at the bottom of vias, trenches, and other semiconductor device structures.

FIGS. 1 through 6 illustrate cross-sectional views of a semiconductor device 100 at various stages of manufacturing in accordance with some embodiments of the present disclosure. Referring first to FIG. 1, there is shown a cross-sectional view of a semiconductor device 100. To manufacture the semiconductor device 100, a workpiece 102 is provided. The workpiece 102 may include a semiconductor substrate comprising silicon or other semiconductor materials and may be covered by an insulating layer, for example. The workpiece 102 may also include other active components or circuits, not shown. The workpiece 102 may comprise silicon oxide over single-crystal silicon, for example. The workpiece 102 may include other conductive layers or other semiconductor elements, e.g., transistors, diodes, etc. Compound semiconductors, GaAs, InP, Si/Ge, or SiC, as examples, may be used in place of silicon. The workpiece 102 may comprise a silicon-on-insulator (SOI) or a germanium-on-insulator (GOI) substrate, as examples.

An insulating material layer 104 is deposited or formed over the workpiece 102, as shown in FIG. 2. The insulating material layer 104 comprises a dielectric material such as silicon dioxide, silicon nitride, other insulators, or combinations thereof having a thickness of about 80 nm to about 300 nm, as examples. In some embodiments, the insulating material layer 104 comprises a low dielectric constant (k) material having a dielectric constant or k value of less than about 3.9, which is the dielectric constant of silicon dioxide, for example. In other embodiments, the insulating material layer 104 comprises an extreme low k (ELK) material having a k value of less than about 2.5, as another example. The insulating material layer 104 may be formed by chemical vapor deposition (CVD), a spin-on method, or physical vapor deposition (PVD), as examples. Alternatively, the insulating material layer 104 may comprise other materials and dimensions, and may be formed using other methods.

Conductive features 106 are formed in the insulating material layer 104, as shown in FIG. 2. The conductive features 106 comprise conductive lines or conductive plugs in some embodiments, for example. The conductive features 106 may be formed using a damascene technique or a subtractive etch technique, as examples. The conductive features 106 comprise copper, a copper alloy, other metals, or multiple layers or combinations thereof in some embodiments. Alternatively, the conductive features 106 may comprise other materials and may be formed using other methods.

An etch stop layer 110 is formed over the insulating material layer 104 and conductive features 106, as shown in FIG. 3. The etch stop layer 110 comprises a high selectivity etch stop layer in accordance with some embodiments. The etch stop layer 110 has an etch selectivity to a material layer of the workpiece 104 of greater than about 4 to about 30 in some embodiments. For example, the etch stop layer 110 has an etch selectivity to the insulating material layer 104 of greater than about 4 to about 30 in some embodiments. In other embodiments, the etch stop layer 110 has an etch selectivity to

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a subsequently deposited insulating material layer **114** (which is also shown in FIG. **3**) of greater than about 4 to about 30. In yet other embodiments, the etch stop layer **110** has an etch selectivity to a subsequently deposited insulating material layer **124** of greater than about 4 to about 30 (not shown; see FIG. **8**). In the embodiments shown in FIGS. **1** through **6**, the etch stop layer **110** has an etch selectivity to insulating material layer **104** and/or insulating material layer **114** that comprise ELK materials of about 4 to about 30, for example.

The terms “first”, “second”, and “third” are used herein with respect to the various insulating material layers **104**, **114**, and **124**, e.g., in some of the claims, in the order of introduction into the claims and/or the semiconductor device **100** structure.

The term “etch selectivity” used herein refers to the (etch rate of insulating material layer **104**, **114**, or **124**)/(etch rate of the etch stop layer **110** or **112**). For example, an etch selectivity of about 10 would result in insulating material layer **104** or **114** being removed during an etch process at a rate that is about 10 times faster than the etch stop layer **110** is removed during the etch process: the etch rate ratio is 10/1, which is equal to an etch selectivity of about 10.

The etch stop layer **110** may be formed using CVD, PVD, or other methods. The etch stop layer **110** comprises a thickness comprising dimension d_1 of about 100 Angstroms (Å) or less in some embodiments. In the embodiments shown in FIGS. **1** through **6**, the etch stop layer **110** comprises a thickness of about 5 Å to about 100 Å, for example. The etch stop layer **110** comprises an insulating material comprising Al, Ti, Ta, Mn, O, N, or combinations thereof in some embodiments, for example. In some embodiments, the etch stop layer **110** comprises a metal compound, wherein the metal compound comprises a metal oxide, a metal nitride, a metal carbide, a metal boride, or a combination of two or more thereof. The metal compound comprises one or more metal elements selected from ruthenium (Ru), nickel (Ni), cobalt (Co), chromium (Cr), iron (Fe), manganese (Mn), titanium (Ti), aluminum (Al), hafnium (Hf), tantalum (Ta), tungsten (W), vanadium (V), molybdenum (Mo), palladium (Pd), or silver (Ag). Alternatively, the etch stop layer **110** may comprise other dimensions and materials.

An etch stop layer **112** is formed over the etch stop layer **110**, also shown in FIG. **3**. The etch stop layer **112** comprises a different material than etch stop layer **110** in some embodiments. The etch stop layer **112** comprises a material having different properties than etch stop layer **110** in other embodiments, for example. Etch stop layer **112** has a different etch selectivity to a material layer of the workpiece **102** such as insulating material layers **104** and **114** than etch stop layer **110**. Etch stop layer **112** has a lower etch selectivity to a material layer of the workpiece **102** such as insulating material layers **104** and **114** (and also **124** shown in FIG. **8**) than etch stop layer **110** in some embodiments. Etch stop layer **112** has an etch selectivity to a material layer of the workpiece **102** such as insulating material layers **104** and **114** of about 1.5 to about 4 in some embodiments, for example. In other embodiments, the etch stop layer **112** has an etch selectivity to a material layer of the workpiece **102** of about 4 or less, for example.

In some embodiments, etch stop layer **110** comprises a first etch stop layer **110**, and etch stop layer **112** comprises a second etch stop layer **112**, for example. The first etch stop layer **110** has a first etch selectivity, and the second etch stop layer **112** has a second etch selectivity, the first etch selectivity being greater than the second etch selectivity. The first etch selectivity is greater than the second etch selectivity by about

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10 or more in some applications, for example. The terms “first”, “second”, and “third” are used herein with respect to the various etch stop layers **110** and **112**, e.g., in some of the claims, in the order of introduction into the claims and/or the semiconductor device **100** structure.

The etch stop layer **112** may be formed using CVD, PVD, or other methods. The etch stop layer **112** comprises a thickness of about 1,000 Å or less in some embodiments. In the embodiments shown in FIGS. **1** through **6**, the etch stop layer **112** comprises a thickness of about 10 Å to about 500 Å, for example. The etch stop layer **112** comprises an insulating material comprising Si, C, N, O, H, or combinations thereof in some embodiments, for example. The etch stop layer **112** comprises a silicon compound. In some embodiments, the silicon compound comprises silicon oxide, a silicon nitride, a silicon carbide, a silicon boride, other materials, or multiple layers or combinations thereof. The etch stop layer **112** comprises a conventional etch stop material comprised of SiC or SiN in some embodiments, for example. Alternatively, the etch stop layer **112** may comprise other dimensions and materials.

An insulating material layer **114** is then formed over the etch stop layer **112**, as shown in FIG. **3**. The insulating material layer **114** comprises a similar material and dimension and is deposited by a similar method as described for insulating material layer **104**, for example. The insulating material layer **114** may comprise the same material as insulating material layer **104**, or the insulating material layer **114** may comprise a different material than insulating material layer **104**.

A hard mask **116** is formed over insulating material layer **114**. The hard mask **116** may comprise silicon nitride, silicon oxynitride, silicon dioxide, or other insulating materials, as examples. The hard mask **116** comprises a thickness of about 10 nm to about 40 nm and is deposited by CVD or PVD, as examples. The hard mask **116** may comprise a material with a greater structural strength than insulating material layer **114**, which comprises an ELK material in some embodiments, for example. Alternatively, the hard mask **116** may comprise other materials and dimensions, and may be formed using other methods. The hard mask **116** is not included in some embodiments, to be described further herein.

Next, insulating material layer **114** is patterned using a lithography process, using etch stop layers **112** and **110** as an etch stop, as shown in FIGS. **3**, **4**, and **5**. For example, a layer of photoresist **118** may be deposited over the hard mask **116**, as shown in FIG. **3**. The layer of photoresist **118** is patterned using lithography with a desired pattern for insulating material layer **114**, as shown in FIG. **4**. The layer of photoresist **118** may be patterned by exposing the layer of photoresist **118** to energy transmitted through or reflected from a lithography mask having a desired pattern thereon. The layer of photoresist **118** is developed, and then exposed or unexposed portions (depending on whether the photoresist **118** is positive or negative) of the photoresist **118** are ashed or etched away. The hard mask **116** or the hard mask **116** and insulating material layer **114** are then exposed to an etch process, removing portions of the hard mask **116** or the hard mask **116** and insulating material layer **114** not covered by the layer of photoresist **118**. Portions of the etch stop layers **112** and **110** are also removed during the etch process, as shown in FIG. **5**. The layer of photoresist **118** is then removed, also shown in FIG. **5**.

In some embodiments, the hard mask **116** is not included. The insulating material layer **114** is patterned using the layer of photoresist **118** as an etch mask during the etch process in these embodiments, for example. In other embodiments, the hard mask **116** is included, and only the hard mask **116** is

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patterned using the layer of photoresist **118** as an etch mask. The layer of photoresist **118** is then removed, and the hard mask **116** is used as an etch mask while portions of insulating material layer **114** are etched away. The hard mask **116** is left remaining in the structure in some embodiments. In other

embodiments, the hard mask **116** is removed before subsequent manufacturing process steps of the semiconductor device **100**. In yet other embodiments, the layer of photoresist **118** and also the hard mask **116** are used as an etch mask during the etch process that is used to pattern the insulating material layer **114**, as another example.

The etch stop layers **112** and **110** function as endpoint detectors in the etch process used to pattern the insulating material layer **114**. The chemicals in the chamber the semiconductor device **100** is placed in for the etch process may be monitored to detect one or more components of the etch stop layers **112** and **110**, for example. When the one or more components of the etch stop layers **112** and **110** are detected, the etch process is discontinued, for example. The thickness comprising dimension d_1 of etch stop layer **110** may be selected so that substantially all of etch stop layer **110** is removed when the etch process reaches the etch stop layer **110**, for example, in some embodiments. In other embodiments, the endpoint detection system or method may involve monitoring chemicals of the etch process to detect when one or more components of etch stop layer **110** ceases to be detected, upon which point the etch process is discontinued, as another example. Alternatively, other types of endpoint detection methods may be used to determine when the etch stop layers **112** and **110** have been reached, indicating that the etch process for the insulating material layer **114** should be discontinued.

In accordance with some embodiments, etch stop layer **112** has a lower etch selectivity with respect to the insulating material layer **114** than etch stop layer **110**. Thus, the entire thickness of the etch stop layer **112** is removed in the patterned regions. Etch stop layer **110** has a high etch selectivity with respect to the material of the material insulating material layer **114** and also to the etch stop layer **112** in some embodiments, advantageously.

Patterns **122** and **123** formed in the insulating material layer **114** may comprise fully landed patterns **122** and partially landed patterns **123** in some embodiments, as shown in FIG. 5. The patterns **122** and **123** comprise patterns for conductive vias of the semiconductor device **100** in some embodiments, for example. Alternatively, the patterns **122** and **123** may comprise patterns for other conductive features, such as conductive lines. The fully landed pattern **122** is formed directly over a top surface of one of the conductive features **106**. The fully landed pattern **122** comprises an opening in the insulating material layer **114**, in the etch stop layer **112**, and in the etch stop layer **110** over a top surface of a conductive feature **106**. In some embodiments, all of the patterns are fully landed.

The partially landed pattern **123** comprises an opening in the insulating material layer **114**, in the etch stop layer **112**, and in the etch stop layer **110** over a portion of a top surface of a conductive feature **106** and also over a portion of a top surface of insulating material layer **104**. In some embodiments, all of the patterns are partially landed. A recess **120** may be formed in the partially landed pattern **123** due to a slight over-etch of insulating material layer **104** during the etch process used to form the patterns **122** and **123** in the insulating material layer **114**, for example. Because the etch stop layer **110** has a high etch selectivity with respect to the material of insulating material layer **104**, a depth of the recess **120** comprising dimension d_2 is advantageously minimized.

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Dimension d_2 comprises about 50 Å or less in accordance with some embodiments; however, dimension d_2 may alternatively comprise other values. In some embodiments, no recess **120** is formed. Dimension d_2 comprises zero in those

embodiments, for example.

Referring next to FIG. 6, a conductive material **126** is deposited or formed over the patterned insulating material layer **114** and hard mask **116**, if the hard mask **116** is included. The conductive material **126** comprises copper, a copper alloy, a conductive liner, a seed layer, or combinations or multiple layers thereof, as examples. The conductive material **126** may be sputtered on, or formed by CVD, PVD, or plating, as examples. Alternatively, the conductive material **126** may comprise other materials and may be formed using other methods. The conductive material **126** fills the patterns in the insulating material layer **114**, the etch stop layer **112**, and the etch stop layer **110**, forming conductive features **128** and **129** within the insulating material layer **114**. In some embodiments, the conductive features **128** and **129** comprise vias **128** and **129** that are electrically coupled to the underlying conductive features **106** within insulating material layer **104**. In region **130** where the recess **120** in the upper portion of insulating material layer **104** resides, the conductive material **126** also fills the recess **120**. Advantageously, the amount of conductive material **126** that fills the recess **120** is minimized due to the minimized size of the recess **120** by the use of the novel etch stop layer **110** having the high etch selectivity. In some embodiments, a portion of a partially landed conductive feature **129** is disposed below a top surface of the first insulating material layer by about 50 Angstroms or less and fills the recess **120**, for example. The formation of voids in the upper portion of insulating material layer **104** within the conductive material **126** in the recess **120** is advantageously avoided, due to the minimized or reduced size of the recess **120** or due to the avoidance of the formation of a recess **120** in accordance with some embodiments of the present disclosure.

The fabrication process for the semiconductor device **100** is then continued. The conductive material **126** residing on the top surface of the hard mask **116** may be patterned to form conductive lines, or a chemical-mechanical polishing (CMP) process may be used to remove the conductive material **126** from the top surface of the hard mask **116**, leaving conductive features comprising the vias **128** and **129** formed within the insulating material layer **114**. Additional material layers (not shown) may be formed over the semiconductor device **100**, and individual integrated circuits may be singulated from the semiconductor device **100** and later packaged in single packages, multi-chip packages, or directly mounted in an end application (also not shown).

FIG. 7 is a cross-sectional view illustrating a semiconductor device **100** in accordance with some embodiments of the present disclosure. The manufacturing process flow for the semiconductor device **100** is similar to the process flow of described for FIGS. 1 through 6; however, etch stop layer **112** is not included in the material stack. For example, etch stop layer **110** comprises a single etch stop layer **110** that is disposed between insulating material layer **104** and insulating material layer **114**. Etch stop layer **110** comprises a similar material described for etch stop layer **110** of the previous embodiments, for example. The etch stop layer **110** has a thickness comprising dimension d_3 , wherein dimension d_3 comprises about 10 Å to about 100 Å in the embodiments shown in FIG. 7, for example. The etch stop layer **110** comprises an etch selectivity to a material layer of the workpiece **102**, such as insulating material layers **104** or **114**, of about 10 to about 200 in some of the embodiments shown in FIG. 7, for

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example. In other embodiments, the etch stop layer **110** comprises an etch selectivity to a material layer of the workpiece **102** of greater than about 4 to about 30, as another example. The inclusion of the novel etch stop layer **110** having the high selectivity advantageously minimizes the depth of the recess **120** or avoids a formation of the recess **120** in the top surface of insulating material layer **104** in a partially landed via pattern **123**.

FIGS. **8** and **9** are cross-sectional views illustrating a method of manufacturing a semiconductor device **100** in accordance with other embodiments of the present disclosure. The etch stop layer **110** having the high selectivity to a material layer of the workpiece **102**, such as insulating material layers **114** or **124**, is included between insulating material layer **114** and insulating material layer **124** in these embodiments. Insulating material layer **124** comprises a similar material and dimension as described herein for insulating material layers **104** and **114**, for example. Insulating material layer **124** may comprise the same material, or a different material, than insulating material layers **104** and **114**, for example. Etch stop layer **110** is disposed above etch stop layer **112** in the material stack. Insulating material layers **114** and **124** may comprise a single insulating material layer **114/124**, for example, and the etch stop layer **110** is placed within the single insulating material layer **114/124**. The etch stop layer **110** comprises a thickness of dimension d_4 , wherein dimension d_4 comprises about 10 Å to about 100 Å in the embodiments shown in FIGS. **8** and **9**. Alternatively, the etch stop layer **110** may comprise other dimensions. The etch stop layer **110** has an etch selectivity of about 10 to about 200 to insulating material layer **114** and/or **124** in the embodiments shown in FIGS. **8** and **9** in some embodiments. In other embodiments, etch stop layer **110** has an etch selectivity to a material layer of the workpiece of greater than about 4 to about 30. Etch stop layer **112** is disposed over insulating material layer **104** and conductive features **106**, beneath insulating material layer **114**. Etch stop layer **110** has an etch selectivity that is about 10 times greater than the etch selectivity of etch stop layer **112**.

The insulating material layers **114** and **124** are patterned using one or more lithography processes to form via patterns **122** in insulating material layer **114** and conductive line patterns **132** and **134** in insulating material layer **124**. Etch stop layer **112** is used as an etch stop to pattern insulating material layer **114**, and etch stop layer **110** is used as an etch stop to pattern insulating material layer **124**, for example, in a dual damascene patterning process. Etch stop layer **110** has a high selectivity to the insulating material **114** and/or **124**, improving the uniformity of the patterns **132** and **134** formed in insulating material layer **124**. For example, some patterns **132** may comprise a smaller width comprising dimension d_5 than other patterns **134** have a larger width comprising dimension d_6 . The inclusion of the high selectivity etch stop layer **110** results in both patterns **132** and **134** having substantially a same depth comprising dimension d_7 , advantageously improving the uniformity of the height or thickness of patterns **132** and **134** across the surface of the semiconductor device **100**.

A conductive material **126** is formed over the semiconductor device **100**, as shown in FIG. **9**. Excess portions of the conductive material **126** are removed from over the top surface of the hard mask **116** using a chemical-mechanical polishing (CMP) process. Narrow patterns **132** and wide patterns **134** form conductive lines **138** that have substantially the same height or depth comprising dimension d_7 on the semiconductor device **100** due to the inclusion of the etch stop layer **110**, advantageously. The lower portion of the patterns

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122 in etch stop layer **110**, insulating material layer **114**, and etch stop layer **112** form vias **136** that are coupled to conductive features **106** formed within underlying insulating material layer **104**.

FIGS. **10** and **11** are cross-sectional views of a semiconductor device **100** at various stages of manufacturing in accordance with other embodiments. FIG. **10** illustrates some embodiments wherein etch stop layer **110** is included between insulating material layers **114** and **124** to improve the uniformity of conductive lines formed in insulating material layer **124**, similar to the embodiments shown in FIGS. **8** and **9**. An etch stop layer **110** is also included beneath etch stop layer **112**, similar to the embodiments shown in FIGS. **1** through **6**. The etch stop layer **110** disposed beneath etch stop layer **112** comprises an etch selectivity to a material layer of the workpiece **102** of about 10 to about 200 in some embodiments, for example. The via patterns **122** are both fully landed. Including the etch stop layer **110** also beneath etch stop layer **112** reduces the size of a recess **120** in insulating material layer **104** in partially landed via patterns **123**, as shown in FIG. **11**.

In some embodiments, etch stop layer **112** is not included in the semiconductor device **100**, not shown in FIGS. **10** and **11**. One of the etch stop layers **110** comprises an etch selectivity to a material layer of the workpiece **102** of greater than about 15 to about 200, and the other of the etch stop layers **110** comprises an etch selectivity to a material layer of the workpiece **102** of about 10 to about 200 in these embodiments, for example. Alternatively, both of the etch stop layers **110** may comprise an etch selectivity of greater than about 4 to about 30.

FIG. **12** is a cross-sectional view of a semiconductor device **100** in accordance with some embodiments of the present disclosure. These embodiments are similar to the embodiments shown in FIGS. **1** through **6**. However, in FIG. **12**, the etch stop layer **110'** comprises a high etch selectivity layer having an etch selectivity with respect to a material layer of the workpiece **102** of about 3 to about 20 in some embodiments. The etch stop layer **110'** is formed by one or more metal elements that are introduced into a top surface of the insulating material layer **104** by predetermined distance, transforming the top portion of the insulating material layer **104** into the etch stop layer **110'** comprising a low etch rate layer that etches at a lower rate than the insulating material layer **104**. Etch stop layer **110'** comprises a thickness of about 20 Å to about 100 Å in some embodiments, for example. Etch stop layer **110'** comprises a material of the insulating material layer **104** combined with one or more metal elements. The etch stop layer **110'** comprises a metal compound. The metal compound comprises a metal oxide, a metal nitride, a metal carbide, a metal boride, or combinations thereof. In some embodiments, the metal compound comprises one or more metal elements selected from ruthenium (Ru), nickel (Ni), cobalt (Co), chromium (Cr), iron (Fe), manganese (Mn), titanium (Ti), aluminum (Al), hafnium (Hf), tantalum (Ta), tungsten (W), vanadium (V), molybdenum (Mo), palladium (Pd), or silver (Ag). Etch stop layer **112** comprises a thickness of about 30 Å to about 500 Å, an etch selectivity to a material layer of the workpiece **102** of about 1.5 to about 4, and a material comprising a silicon compound. The silicon compound comprises silicon oxide, a silicon nitride, a silicon carbide, a silicon boride, or combinations thereof. Alternatively, etch stop layer **110'** and etch stop layer **112** may comprise other etch selectivities, dimensions, and materials. Etch stop layer **110'** comprising the low etch rate layer may be formed by an implantation process of the metal element(s) into the insulating material layer **104**, by the introduction of a

gas containing the metal element(s), or other methods, for example. The low etch rate etch stop layer **110'** reduces via recession at a partially landed via **129** and prevents the formation of a high aspect ratio hole in the underlying insulating material layer **104**, advantageously.

FIG. **13** is a flow chart **140** of a method of manufacturing a semiconductor device **100** in accordance with some embodiments. In step **142**, an etch stop layer **110** is formed over a workpiece **102** (also see FIG. **3**). The etch stop layer **110** has an etch selectivity to a material layer of the workpiece **102** of greater than about 4 to about 30. In step **144**, an insulating material layer **114** or **124** is formed over the etch stop layer **110**. In step **146**, the insulating material layer **114** or **124** is patterned using the etch stop layer **110** as an etch stop (also see FIG. **5**).

Advantages of some embodiments of the disclosure include providing novel semiconductor devices **100** and methods of manufacture thereof that include novel etch stop layers **110** and **110'** having a high etch selectivity. The etch stop layers **110** and **110'** are implementable at the bottom of vias, trenches, and other structures or patterns of semiconductor devices **100**. The etch stop layers **110** and **110'** reduce trench depth variation and control trench height precisely. The novel etch stop layers **110** and **110'** have an etch selectivity that is about 10 times higher than conventional etch stop layers used in semiconductor manufacturing processes in some embodiments.

The etch stop layers **110** and **110'** also prevent or reduce recesses **120** from forming in the underlying insulating material layers **104** at un-landed or partially landed vias. Over-etching of portions of via trenches that are not landed on a conductive feature **106** is avoided or reduced, resulting in shallower recesses **120** or resulting in the prevention of the formation of recesses **120**. The formation of high-aspect ratio recesses at un-landed vias is avoided, the formation of which could cause gap-fill problems and conductive line or dielectric material reliability problems. For example, if a deep recess **120** forms in an insulating material layer **104** at a partially landed via pattern **123** (see FIG. **5**), filling the pattern **123** with a conductive material **126** (see FIG. **6**) can become a challenge, possibly resulting in a void in the conductive material **126** within the recess **120**, which can cause a reliability failure for the semiconductor device **100**.

The etch stop layers **110** and **110'** also reduce etch loading effects. For example, non-uniformities of patterns having different dimensions or located at different positions on a semiconductor wafer is prevented by including the etch stop layer **110** and **110'** within an insulating material layer **114/124** as an etch stop (see FIG. **8**). Varied trench height across a surface of a semiconductor wafer is avoided by the use of the novel etch stop layers **110** and **110'**. Implementing the etch stop layer **110** and **110'** in some applications prevents variations in trench height for patterns having different widths, resulting in patterns having substantially the same height (e.g., see dimension d_7 in FIGS. **8** and **9**). Furthermore, the etch stop layers **110** and **110'** reduce conductive line resistivity variation of semiconductor devices **100** due to the decreased non-uniformity of patterns.

The novel high selectivity etch stop layers **110** and **110'** can be implemented in a bi-layer structure with an additional etch stop layer **112** that comprises a material conventionally used as an etch stop material, as shown in FIGS. **1** through **6**, or the novel etch stop layers **110** may replace conventional etch stop layers, as shown in FIG. **7**. The etch stop layers **110** can also be positioned in the middle of an insulating material layer **114/124**, i.e., for use in dual damascene structures or manufacturing processes, as shown in FIG. **8**. The etch stop layers

110 and **110'** can also be used in combinations of these locations and applications. In addition, the novel etch stop layer **110** and **110'** structures and designs are easily implementable in manufacturing process flows.

In accordance with some embodiments of the present disclosure, a method of manufacturing a semiconductor device includes forming an etch stop layer over a workpiece, the etch stop layer having an etch selectivity to a material layer of the workpiece of greater than about 4 to about 30. The method includes forming an insulating material layer over the etch stop layer, and patterning the insulating material layer using the etch stop layer as an etch stop.

In accordance with other embodiments, a method of manufacturing a semiconductor device includes forming a first insulating material layer over a workpiece, and forming a first etch stop layer over the first insulating material layer. The first etch stop layer has a first etch selectivity to the first insulating material. The method includes forming a second etch stop layer over the first insulating material layer. The second etch stop layer has a second etch selectivity to the first insulating material. The first etch selectivity is different than the second etch selectivity. A second insulating material layer is formed over the second etch stop layer, and the second insulating material layer is patterned using the first etch stop layer as an etch stop. In some embodiments, the method comprises first, forming the first etch stop layer, and second, forming the second etch stop layer. In other embodiments, the method comprises first, forming the second etch stop layer, and second, forming the first etch stop layer.

In accordance with other embodiments, a semiconductor device includes a first insulating material layer disposed over a workpiece, and an etch stop layer disposed over the first insulating material layer. The etch stop layer has an etch selectivity to the first insulating material layer of greater than about 4 to about 30. A second insulating material layer is disposed over the etch stop layer. A plurality of conductive features is disposed in the second insulating material layer. A bottom region of one of the plurality of conductive features disposed in the second insulating material layer is disposed proximate a top surface of the first insulating material layer.

Although some embodiments of the present disclosure and their advantages have been described in detail, it should be understood that various changes, substitutions and alterations can be made herein without departing from the spirit and scope of the disclosure as defined by the appended claims. For example, it will be readily understood by those skilled in the art that many of the features, functions, processes, and materials described herein may be varied while remaining within the scope of the present disclosure. Moreover, the scope of the present application is not intended to be limited to the particular embodiments of the process, machine, manufacture, composition of matter, means, methods and steps described in the specification. As one of ordinary skill in the art will readily appreciate from the disclosure of the present disclosure, processes, machines, manufacture, compositions of matter, means, methods, or steps, presently existing or later to be developed, that perform substantially the same function or achieve substantially the same result as the corresponding embodiments described herein may be utilized according to the present disclosure. Accordingly, the appended claims are intended to include within their scope such processes, machines, manufacture, compositions of matter, means, methods, or steps.

What is claimed is:

1. A method of manufacturing a semiconductor device, the method comprising:

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forming a first etch stop layer over a workpiece, the etch stop layer having an etch selectivity to a material layer of the workpiece;

forming a second etch stop layer over the first etch stop layer,

forming an insulating material layer over the second etch stop layer;

patterning the insulating material layer using the second etch stop layer as an etch stop;

etching the second etch stop layer exposed by the patterning using the first etch stop layer as an etch stop; and removing the portions of the first etch stop layer exposed by the etching.

2. The method according to claim 1, wherein forming the insulating material layer comprises forming a second insulating material layer, wherein the workpiece includes a first insulating material layer disposed proximate a top surface thereof, wherein the first insulating material layer includes a plurality of conductive features formed therein, and wherein patterning the insulating material layer comprises forming a pattern over one of the plurality of conductive features.

3. The method according to claim 2, wherein the second etch stop layer has an etch selectivity to the material layer of the workpiece of about 4 or less.

4. The method according to claim 1, wherein the workpiece includes a first insulating material layer disposed proximate a top surface thereof, wherein the first insulating material layer includes a plurality of conductive features formed therein.

5. The method according to claim 4, wherein the second etch stop layer has an etch selectivity to the first insulating material layer of the workpiece of about 4 or less.

6. The method according to claim 4, wherein the first etch stop layer comprises an etch selectivity to the material layer of the workpiece of about 10 to about 200.

7. The method according to claim 6, further comprising forming a third etch stop layer over the insulating material layer, the third etch stop layer having an etch selectivity to the insulating material layer of about 4 or less.

8. A method of manufacturing a semiconductor device, the method comprising:

forming a first insulating material layer over a workpiece; forming a first etch stop layer over the first insulating material layer, the first etch stop layer having a first etch selectivity to the first insulating material;

forming a second etch stop layer over the first etch stop layer, the second etch stop layer having a second etch selectivity to the first etch stop layer, the first etch selectivity being different than the second etch selectivity;

forming a second insulating material layer over the second etch stop layer;

patterning the second insulating material layer using the first etch stop layer as an etch stop;

patterning the second etch stop layer using the first etch stop layer as an etch stop; and

patterning the first etch stop layer using the second etch stop layer as a pattern.

9. The method according to claim 8, wherein the patterning the second etch stop layer is performed with an etch that is selective to the second etch stop layer over the first etch stop layer and the second insulating material.

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10. The method according to claim 8, wherein the first etch stop layer comprises a material of the first insulating material layer combined with a metal element.

11. The method according to claim 8, wherein the first etch selectivity is greater than the second etch selectivity by about 10 or more.

12. The method according to claim 8, wherein the first etch stop layer comprises a metal compound comprising a metal oxide, a metal nitride, a metal carbide, a metal boride, or combinations thereof.

13. The method according to claim 12, wherein the metal compound comprises one or more metal elements selected from ruthenium (Ru), nickel (Ni), cobalt (Co), chromium (Cr), iron (Fe), manganese (Mn), titanium (Ti), aluminum (Al), hafnium (Hf), tantalum (Ta), tungsten (W), vanadium (V), molybdenum (Mo), palladium (Pd), or silver (Ag).

14. The method according to claim 8, wherein the second etch stop layer comprises a silicon compound comprising silicon oxide, a silicon nitride, a silicon carbide, a silicon boride, or combinations thereof.

15. A method of manufacturing a semiconductor device, the method comprising:

forming a first etch stop layer over an insulating layer, the etch stop layer having an etch selectivity to the insulating layer of greater than about 4 to about 30;

forming a second etch stop layer on the first etch stop layer, the second etch stop layer having an etch selectivity to the first etch stop layer of 10 to 200;

forming an insulating material layer over the etch stop layer;

patterning the insulating material layer using the second etch stop layer as an etch stop;

patterning the second etch stop layer using the insulating material layer as a pattern and the first etch stop as an etch stop; and

patterning the first etch stop layer using the second etch stop as a pattern.

16. The method according to claim 15, wherein patterning the second etch stop layer is performed with an etch that is selective to the second etch stop layer over the first etch stop layer and the second insulating material.

17. The method according to claim 15, wherein the first etch stop layer comprises a material of the insulating layer combined with a metal element.

18. The method according to claim 15, wherein the first etch stop layer comprises a metal compound comprising a metal oxide, a metal nitride, a metal carbide, a metal boride, or combinations thereof.

19. The method according to claim 18, wherein the metal compound comprises one or more metal elements selected from ruthenium (Ru), nickel (Ni), cobalt (Co), chromium (Cr), iron (Fe), manganese (Mn), titanium (Ti), aluminum (Al), hafnium (Hf), tantalum (Ta), tungsten (W), vanadium (V), molybdenum (Mo), palladium (Pd), or silver (Ag).

20. The method according to claim 15, wherein the second etch stop layer comprises a silicon compound comprising silicon oxide, a silicon nitride, a silicon carbide, a silicon boride, or combinations thereof.

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